

628-024

40

Date: Wednesday, 9/12/2007 12:06:30 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	FLOAT STEP ASSEMBLY RH (206/407)		
Job Number	34576A				
Estimate Number	11775				
P.O. Number	N/A	Part Number	D2842042		
This Issue	9/12/2007	S.O. No.	N/A		
Prsh Rev.	NC	Drawing Number	D2842 REV B		
First Issue	N/A	Project Number	N/A		
Previous Run	33924A	Drawing Revision	B		
Written By		Material	N/A		
Checked & Approved By		Due Date	9/30/2007 Qty: 4 Um: Each		
Comment	Est Rev:D As Per Ecn 766 06-01-06 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
Comment:	Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B34016</u>
Check Material for any Dents or Defects			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment:	LARGE FABRICATION RESOURCE 1		
1-Cut D2842-1 using D2622 extrusion as per Dwg D2842			
			<u>a.m 07.09.13</u>
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842			
			<u>16 07.09.13</u>
3-Deburr and bevel ends for welding			
3.0	D2734	206 Step Endplate	
Comment:	Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
206 Step Endplate			
Pick:			
Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>333861</u>
4.0	D34591	plate	
Comment:	Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
plate	<u>B 33807 = 1</u>		
Batch:	<u>B 34429 = 7</u>		
			<u>16 07.09.13</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:06:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 34576A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

plate

Batch: 334430

SL 01.09.13

4

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: M103794  
M104721

2-Grind end cap weld flush

SL 01.09.17

4

A.M

07.09.18

Y

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/18 (4)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M

07.09.18

Y

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.09.19

4

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

P.E.

07.09.19

4

✓ A.M

07.09.19

Y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:06:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 34576A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL Rod Batch: M103794

*16/09/18*

4

2-Grind end cap weld flush.

*am 07.09.20*

4

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*M07/09/21 (4)*

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5/09/21 (4) RH*

14.0 POWDER COATING

POWDER COATING



*M105068 M-L*



*07/09/24*

*RH  
4X*

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FZ 07/09/25 (4)*

16.0 NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3 NAS1329C3KB130 Insert

*m105385*

*FZ*

17.0 MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07 Screw

*m105426*

*FZ*

18.0 NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3L WASHER

*m104603*

*FZ 07/09/25 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: CD Date: 07/07/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

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Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 34576A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

m104537

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m105694

FL 07/09/25 (D)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CO 07/09/05 (4RH)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 34576A

7/9/26 5d (4X)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/09/26

(4)

Job Completion



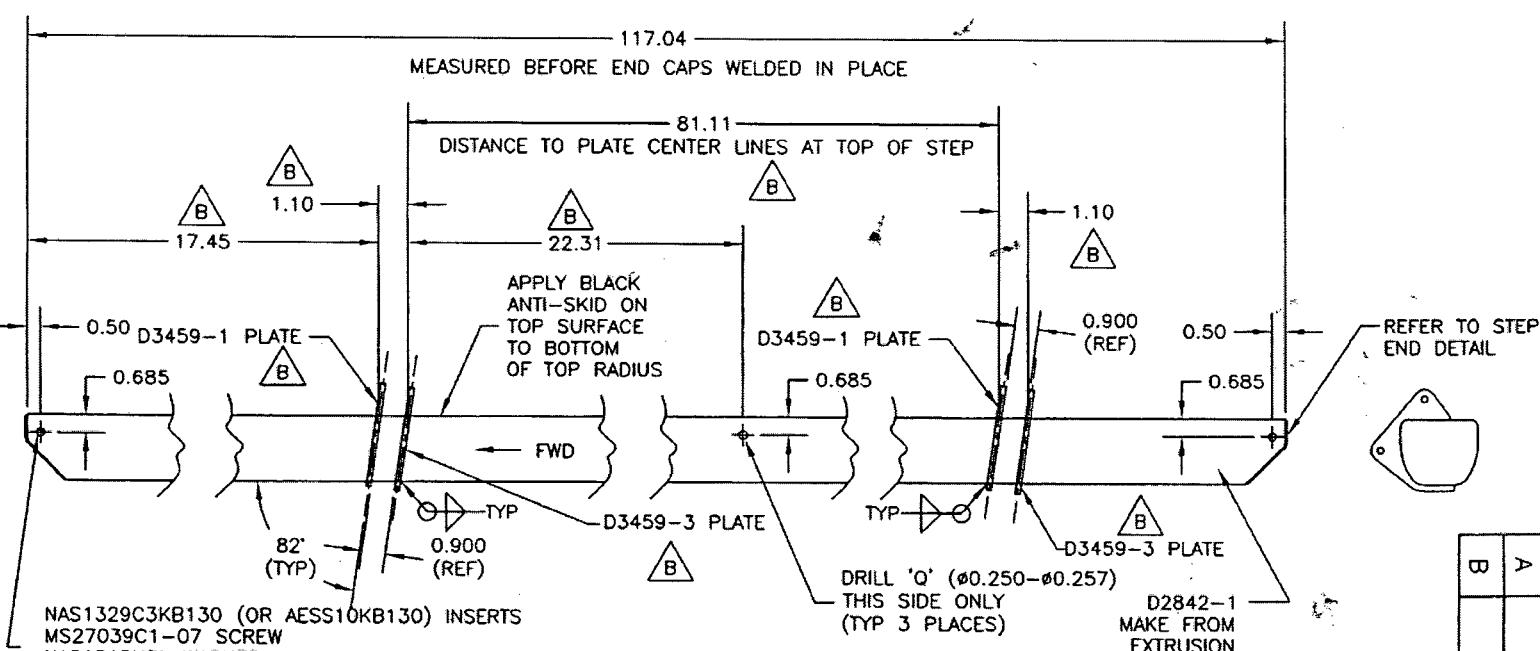
10/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

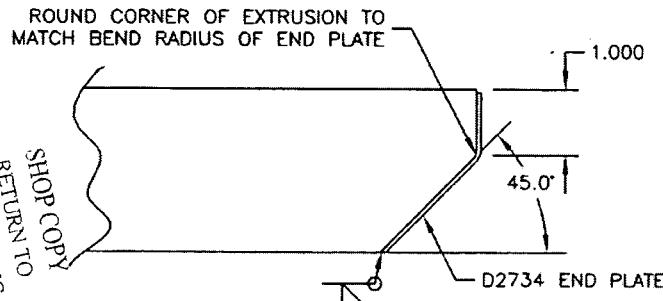


D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
NO. *2005-01*  
WITHOUT NOTICE  
WORK ORDER



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**

*05/14*

**DART**

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2842
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY
A	98.10.13	SHEET 1 OF 1
B	05.09.23	SCALE NTS